

Work Order ID 56077

February 9, 2010 3:36:29 PM



Page 1

Item ID: D3656-1

Accept



Setup Start



Revision ID:

Item Name: PANEL

Stop



Start Date: 2/09/10

Start Qty: 3.00



Cust Item ID:

Required Date: 2/19/10

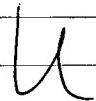
Req'd Qty: 3.00



Customer:

Reference:

Approvals: Process Plan:



Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3656	Rev B

100 0.00

Thermoform HAND FINISHING THERMOFORMING

Thermoforming Machine Memo 0.00

Cut Blanks to fit frame size

BB
10/04/27
X ST

110 0.00

Thermoform THERMOFORMING MACHINE

Thermoforming Machine Memo 0.00

Thermoform as per Dwg. D3656-1 and Folio FTA 015 using tool DT
8986 Dwg. Rev. 3 Folio Rev. C

BB
10/04/27

120 0.00

QC QC2- Inspect parts off machine FAI/FAIB

Quality Control Memo 0.00

Visually inspect for proper formation of each part

P.R. X4
X1 SCAFF
BB
10/04/27

XY
BB
10/04/27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3656-1 PAR #: Fault Category: Thermo forming NCR: Yes No DQA: Date: 10-04-28
 Resolution: scrap Disposition: scrap QA: N/C Closed: Date: 10/05/28

NCR: 56077		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/01/28	100	JUEN JUEN DID NOT RETURN OVER HEATED OTHERS - Did not set off the return switch. R.C. program glitch	QSI442	- Scrap part at 1 panel. - No replace - no extra material.	BB 10/01/27	S 10/04/29	QSI442	1004-28

NOTE: Date & initial all entries

Work Order ID 56077

Page 2

February 9, 2010 3:36:29 PM

Item ID: D3656-1

Accept



Setup

Start



Revision ID:

Item Name: PANEL

Stop



Start Date: 2/09/10 Start Qty: 3.00



Cust Item ID:

Required Date: 2/19/10 Req'd Qty: 3.00



Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run

Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



QC8- Inspect parts - second check

0.00

DR 10/04/27
(X4)

QC

Quality Control

140



HAND FINISHING THERMOFORMING

0.00

DR 10/04/28
(X4)

Thermoform

Thermoforming Machine

Memo

0.00

Trim to Finished Dimensions as per dwg D3656

150



QC2- Inspect parts off machine FAI/FAIB

0.00

DR
10/04/29
X4

QC

Quality Control

Memo

0.00

Check dimensions to ensure conformity to drawing tolerances.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 56077



Page 3

February 9, 2010 3:36:29 PM

Item ID: D3656-1

Accept



Setup Start



Revision ID:

Item Name: PANEL

Stop



Start Date: 2/09/10 Start Qty: 3.00



Cust Item ID:

Required Date: 2/19/10 Req'd Qty: 3.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



QC5- Inspect part completeness to step on W/O

0.00

S. Subbarao



PTO

QC

Memo

0.00

Quality Control

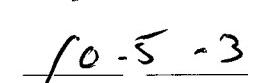
170



Identify as per dwg & Stock Location

179

0.00



30-5-3

Packaging

Memo

0.00

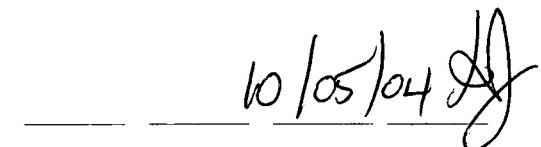
Packaging

180



QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

BB 10-5-04
3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3656-1 PAR #: Fault Category: Thermoforming NCR: Yes No DQA: Date: 16-05-06
 Resolution: scrup Disposition: scrup QA: N/C Closed: HJ Date: 10/05/07

NCR: 56077		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/04/29	# 160	Found orange markings in the part. L.C. pulled across the tube. 2	10.04.29 HJ1042	Scrap & Destroy QH +1 without note	BB. 10/04/29,	✓ 10/04/29 HJ1042	✓ 10/04/29 HJ1042	S 10/04/29

NOTE: Date & initial all entries

Picklist Print

Page 1

February 9, 2010 3:36:33 PM

Work Order ID: 56077



Parent Item: D3656-1



Parent Item Name: PANEL

Start Date: 2/09/10

Required Date: 2/19/10

Comments: IPP Rev. A 07/12/13 New issue DL verified by:DD
IPP Rev. B 08/09/25 Dwg. Update DL.

Start Qty: 3.00

Required Qty: 3.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch Purchased	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MLEXS.093-F6006-07			No			100	sf	211.4885	96.0000			

GE PLASTICS LEXAN SHEET

Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT	211.4884526
107574	16.62
111973	180.609853
112176	14.2586

114459

2

3

BB
10/04/27
X5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	56077
Description: Panel	Part Number:	D3656-1
Inspection Dwg: D3656	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Shape Definition	✓			
Free of visual flaws (bumps, cracks, voids, etc.)	✓			

Measured by: *[Signature]*

Date: 10/04/29

TRIMMING SECTION

Measured by: *[Signature]*

Date: 10/04/25

Audited by: *[Signature]*

Date: 10/04/29

Prototype Approval:

N/A

Date: N/A

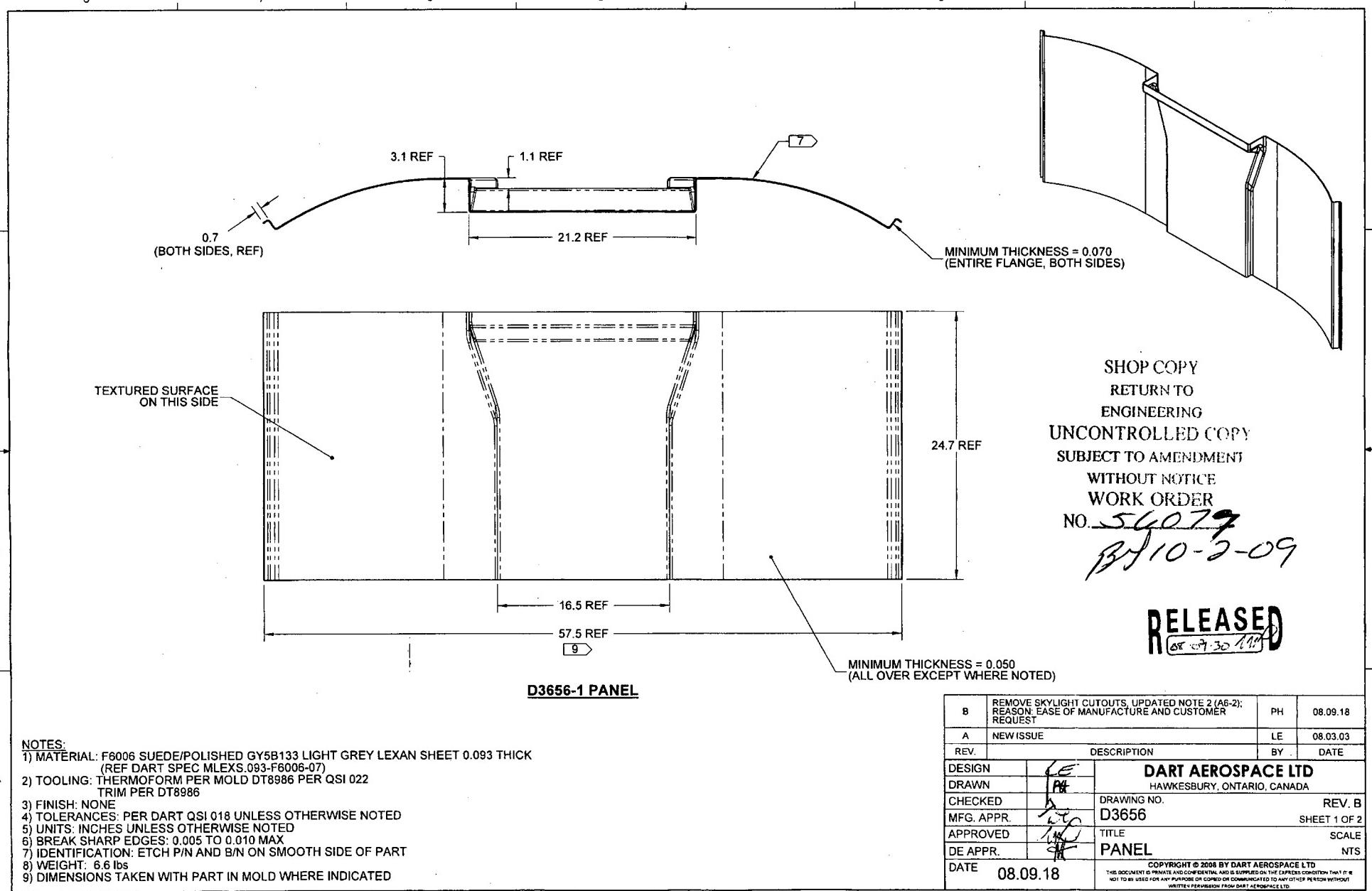
Rev	Date	Change	Revised by	Approved
A	08.05.28	New Issue	KJ/DL	
B	09.09.15	Dimensions updated per Dwg Rev B	KJ	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

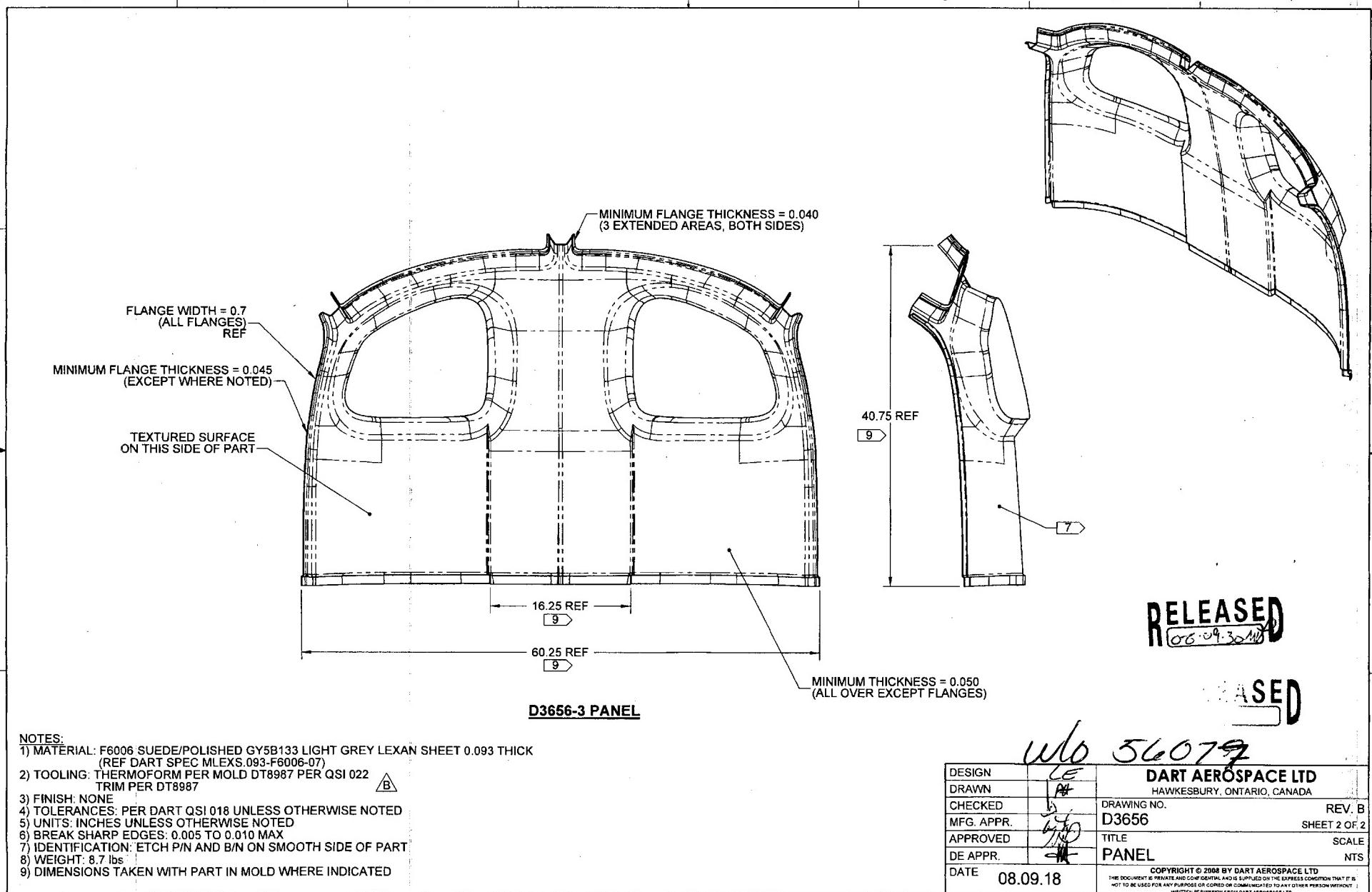


W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries